

Date: Tuesday, 13/05/2008 11:08:47 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DECK PLATE,FWD ,350 LITTER KIT
Job Number : 39239	
Estimate Number : 11104	
P.O. Number :	Part Number : D2364
This Issue : 13/05/2008 S.O. No. :	Drawing Number : D2364 REV.F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 38057	Material :
Written By :	Due Date : 05/06/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JUD 08.5.13</u>	
Comment : EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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S.



Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s) HB 8-5-14
 2024-T3 .063 Aluminum sheet $10492 \times 3 = 2.1$
 (M2024T3S063) 101022×1.7
 Batch: $105615 \times 3 = 2.1$

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2364
 Dwg Rev: F
 Prog Rev: F

HB 8-5-14

⑦

2-Deburr if necessary HB 8-5-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-5-14



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/05/15 (x7)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D2364

EB 08/05/16 ⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 39239

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:20 am

320°F

7:30 am

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57186

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39239
Description: Litter Deck Plate Kit (350)		Part Number: D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.626	*			
Ø0.171	+0.005/-0.000	.173	*			
0.354	+/-0.010	.355	*			
11.242	+/-0.010	11.242	*			
3.031	+/-0.010	3.038	*			
1.903	+/-0.010	1.903	x			
1.128	+/-0.010	1.125	*			
0.354	+/-0.010	.355	*			
1.340	+/-0.005	1.354	*			
2.326	+/-0.010	2.330	*			
3.312	+/-0.010	3.316	*			
4.298	+/-0.010	4.301	*			
5.284	+/-0.010	5.286	*			
6.151	+/-0.010	6.155	*			
6.270	+/-0.010	6.272	*			
0.354	+/-0.010	.354	*			
3.031	+/-0.010	3.036	*			
Ø0.656	+0.005/-0.000	.656	*			
5.003	+/-0.010	5.003	*			
4.605	+/-0.010	4.607	*			
1.776	+/-0.010	1.776	*			
0.980	+/-0.010	.980	*			
4.487	+/-0.010	4.490	*			
7.192	+/-0.010	7.194	*			
7.587.567	+/-0.010	7.570	*			
7.942	+/-0.010	7.947	*			
Ø0.191	+0.005/-0.000	.192	*			
Ø0.197	+0.005/-0.000	.200	*			
11.145	+/-0.010	11.145	*			
12.181	+/-0.010	12.181	*			
11.378	+/-0.010	11.378	*			
11.776	+/-0.010	11.776	*			
12.173	+/-0.010	12.173	*			
4.690	+/-0.010	4.691	*			
0.250	+0.005/-0.000	.251	*			
3.141	+/-0.010	3.145	*			
0.171	+0.005/-0.000	.173	*			

Measured by: B	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-5-14	Date: 08/05/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	[Signature]

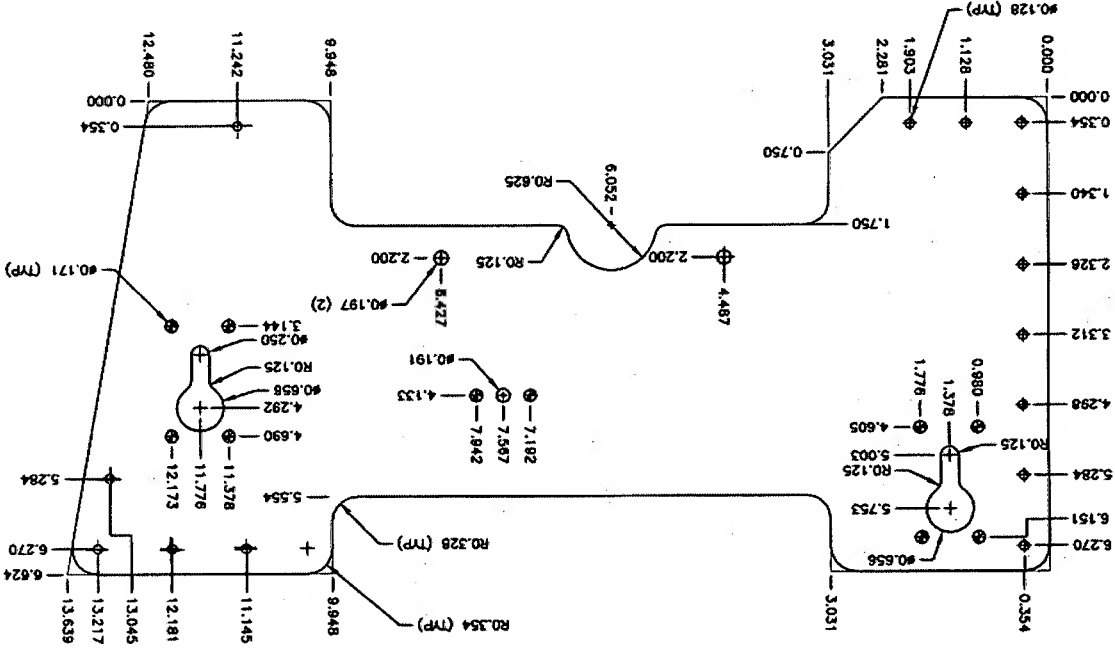
DART



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED KE	DRAWING NO. D2364	REV. F SHEET 1 OF 1
DATE 98.06.19	TITLE LITTER DECK PLATE, 350		
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEYWAY	
D	95.03.06	0.191 WAS 0.197	
E	95.10.06	GEOMETRY CHANGES	
F	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	

RELEASED
R 98/06/22 KE

COUNTER SINK HOLES:
◆ C'SINK Ø0.225 x 100°
● C'SINK Ø0.308 x 100°
(updated from 9 to 14 HOLES BY 05 99.03.01 TO CORRECT CAD ERROR)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.063-0.071 THICK
FINISH: POWDER COAT BLACK CRINKLE (4.3.5.3) PER PART OSI 005 4.3
TOLERANCES ARE PER PART OSI 018 UNLESS OTHERWISE NOTED

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NO 1033